

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012290**Date Inspected:** 27-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress:

Segment # 6AW-PP38

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 050433 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG027-044; The Critical Welding Repair Report (CWR) was B-CWR1138. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-4G (4F)-FCM-Repair-1.

Segment # 7AW-PP48

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG033B-001; The Welding Repair Report (WRR) was B-WR10697. ZPMC QC is identified as Mr.Zhang Hai Tuo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. See the attached below Photo.

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Segment # 6CE-PP47

Repair Welding.

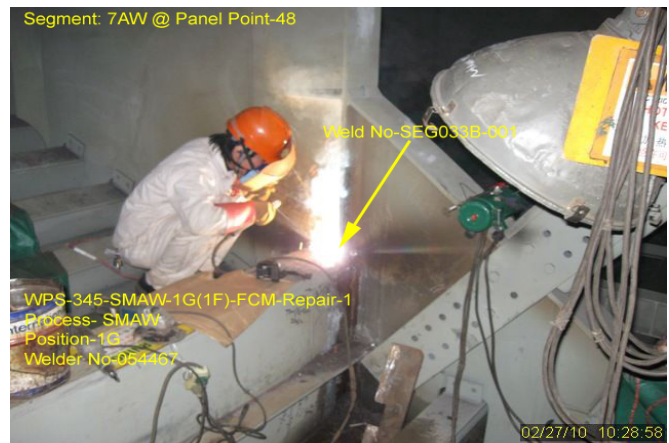
This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG034A-007; The Critical Welding Repair Report (CWR) was B-CWR1211. ZPMC QC is identified as Mr.Zhang Sheng Jun . The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Segment# 6CE-PP44

This QA inspector observed, ZPMC qualified welding personnel identified as 067609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP0528-001-100; ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1.

Segment# 6BW-PP40

This QA inspector observed, ZPMC Quality Control (QC) Ultrasonic Testing (UT) technician identified As Mr.Zhang Xiu perform UT on the Weld joint identified as OBW6F-007; Counter weight to connection plate. See the below attached Photo.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

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Reviewed By: Miller,Mark

QA Reviewer